

# Work Order ID 52470

September 28, 2009 8:36:38 AM



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Item ID:	D3684-043	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	MOUNT ASSEMBLY					
Start Date:	09/25/09	Start Qty:	1.00		Cust Item ID:	
Required Date:	09/30/09	Req'd Qty:	1.00		Customer:	
Reference:	NCR09-084 / RA109098					

Approvals:	Process Plan:		Date:	Tooling:		Date:		Run	Start	
	QC:		Date:	SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3684	Rev C								

100	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Original B44523 from D205-770-011 B44427.								

110		0.00							
Small Fab	Memo	0.00							
Small Fab	Drill open the top 0.257" hole on the D3687-1 mount to a new hole size of 0.261" per NCR09-084.								
	Debur.								
	Ensure hole & debur in clean for NDT.								

*M. K.*  
*09/28/09*




*(IX)*



**Work Order ID 52470**









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Item ID: D3684-043 Accept  Setup Start   
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Reference: NCR09-084 / RA109098

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	<i>2750910968</i>						
130  Outsource2 Outsource process - NDT	Outsource process - NDT per QSI038 4.1  Memo LPI the drilled section of the D3687-1 mount.	0.00 0.00	<i>P/O: 10482</i>			<i>CL 09/09/28</i>			
140  Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs  Memo Ensure NDT results are attached.	0.00 0.00					<i>09 09 28</i>		







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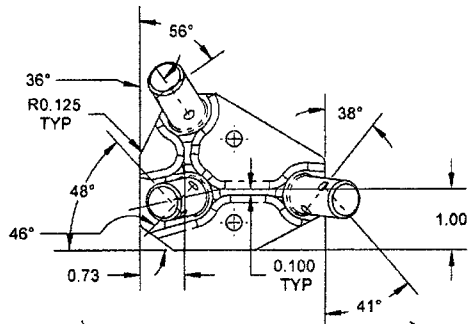
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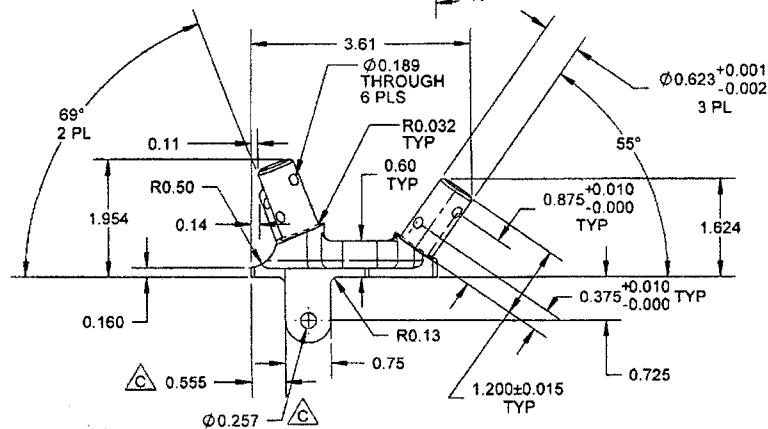
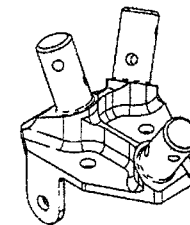
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

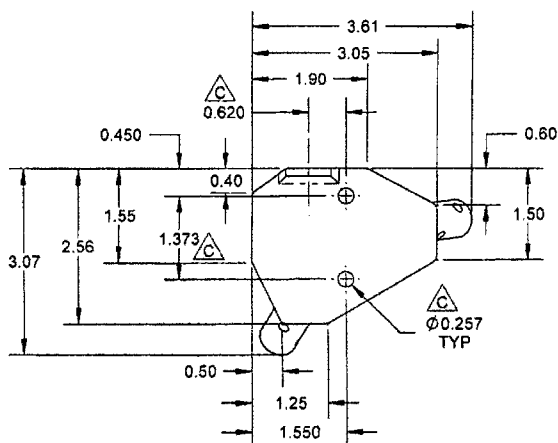
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 27.5 09/10/01 0.00							
160  Packaging Packaging	Identify as per dwg & Stock Location: 270A  Memo Return to stock using the new batch #.	0.00 0.00				9/10/01			
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00				09/10/01			mf 09-10-01



REFERENCE ONLY



# D3687-1 MOUNT



## NOTES:

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

52470

RELEASED  
2009-08-22

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); 0.257 WAS 0.250 (ZN A6-1, B7-1, B7-2)	RF	08.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	9/	DRAWING NO.	REV. C
MFG. APPR.	9/	D3687	SHEET 1 OF 2
APPROVED	10/	TITLE	SCALE
DE APPR.	10/	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



## LIQUID PENETRANT TEST REPORT

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TIME AM ☒ P

CLIENT DART Aerospace DATE SEPT 28-2009  
ATTENTION LINDA / CHARTEL ACUREN JOB NO. 188-09-001561  
ADDRESS 1270 ABELDEEN ST. PO/NO. -10482  
HAWKES BURY ON. WORK LOCATION HAWKES BURY  
KGH 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 200  
PROJECT F.P.I. ON MACHINED PARTS AND  
ITEM(S) EXAMINED CROSS TUBES.

JOB DESCRIPTION STAINLESS STEEL AND PROCEDURE No. LT-0062 REV./DATE 2006 TECHNIQUE No. LT-0062 REV./DATE 2006  
PART NO. 188-09-001561 MATERIAL ALUMINUM THICKNESS -  
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION  
CARRIED OUT 100% EXTERNAL

## TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMU  
FAMILY BRAND 2LG7 - MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$  W/CM<sup>2</sup> ☐ AMBIENT <  
PENETRANT 2LG7 MINIMUM DWELL TIME 10 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ S  
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO  
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 00000000 CAL DUE DATE 07/03  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

## TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE MET  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/ 50°F ☒ 10°C/ 50°F TO 52°C/ 125°F ☐ > 52°C/ 125°F

RESULTS- (☒ METRIC ☐ IMPERIAL)

1 - W.O. 51882 - CROSS TUBE	X
1 - W.O. 51881 - CROSS TUBE	X
1 - W.O. 52334 - CROSS TUBE	X
1 - W.O. 52335 - CROSS TUBE	X
3 - W.O. 52495 - MOUNTS	X
6 - W.O. 51096 - MOUNTS	X
6 - W.O. 51097 - MOUNTS	X

- AN INSPECTION WAS DONE ON W.O. 52470 - ONE ITEM WAS REWORKED DUE TO HOLE SIZE AT BRACKET.  
- EXAMINATION OF THIS AREA WAS CARRIED OUT AND RESULTS AS FOLLOWS  
- FOUND ACCEPTABLE TO CODE  
MM 09 09 28

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, express or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE Eric Downing DTR # E-27840  
TECHNICIAN (SIGNATURE): Mike Johnston SIGNATURE Mike Johnston  
NAME (PRINT): Mike Johnston REPORT REVIEWED BY: Mike Johnston  
1<sup>ST</sup> TECHNICIAN 2<sup>ND</sup> TECHNICIAN  
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL 2 SNT LEVEL 2  
CGSB REG. NO. 6066 CGSB REG. NO. 6066

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